

Work Order ID 55924

February 4, 2010 2:35:00 PM



Page 1

Item ID: D350-636-011

Accept



Setup Start



Revision ID:

Item Name: Skidtube LH

Stop



Start Date: 2/04/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/12/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

PT

Date: 10-2-01 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00



DOCUMENT CONTROL

DC

0.00

Document Control

Memo

Photocopy blue file and type labels per PPP D350-636-011 CHG 005

5/10/03/03

HG BG 10/03/02

55924

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55924

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Page 2

Item ID: D350-636-011

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Revision ID:

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Item Name: Skidtube LH

Start Date: 2/04/10 Start Qty: 1.00

Cust Item ID:

Required Date: 2/12/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details).Drill using drill Jig DT8150 & DT8863.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4- drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500"

5- locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

6-Open up holes for Detail B to 0.375" (4 holes per side)and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up holes for ground handling and detail C to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

8-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004
A/R ☐ Aluminum Rod ☒ M113207

10-Grind welds flush as per Dwg D2750

416/218

BE 10/02/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 55924

February 4, 2010 2:35:05 PM



Item ID: D350-636-011

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Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 2/04/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/12/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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12- Scribe batch# inside per dwg D2750

BE 10/02/08

120

QC10- Inspect visual per QSI004- ground welds

0.00

=> S 10/02/08



QC

Memo

0.00



Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

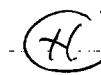
=> S 10/02/08



QC

Memo

0.00



Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

BE 10/02/08

Hand Finishing

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Item ID: D350-636-011

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Customer:

Reference:

Run Start



Approvals: Process Plan: Date:

Tooling: Date:

Stop



QC: Date:

SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

DP

10-2-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐ ☐ ☐ Sikaflex-291

batch: M112429

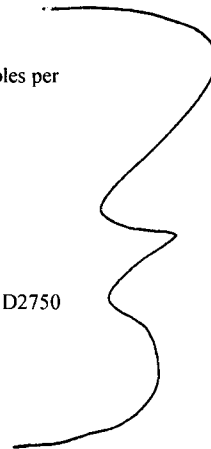
exp. date: 12/19/10

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 8)

A/R ☐ ☐ ☐ Aluminum Rod batch: M113207

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section (total of 4 places per side) as per
dwg D2750



M101219

BE 10/22/10



10-2-17

W/O:		WORK ORDER CHANGES					
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Item Name: Skidtube LH

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Cust Item ID:

Required Date: 2/12/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11- At section AJ-AJ drill out x-bolt spacer to 0.404"

312 10/07/10

12-Deburr holes

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

8 10/02/10

(40)

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8 10/02/10

(40)

f

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 2/12/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Pressure Wash per QSI005 4.3

0.00

BR 10 02-18

0-



HandFinish

TOUCH-UP ALUMINUM
Memo

0.00

Hand Finishing

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

=> 11/13/17 10/02/18

(X) 0



Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:45 AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 11:11 AM

210

QC3- Inspect Part Finish

0.00

BR 10-2-20

0-



QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

W/O:		WORK ORDER CHANGES					
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Work Order ID 55924

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Item ID: D350-636-011

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Setup Start



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Item Name: Skidtube LH

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Cust Item ID:

Required Date: 2/12/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220



HandFinish

Hand Finishing

HandFinishing

Memo

1- Install inserts as per Dwg D2750

0.00

0.00

=> 81 10/02/26

(X) 0

230



HandFinish

Hand Finishing

HandFinishing

Memo

1- Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: 1117

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750
SIKA FLEX 241

BATCH: 1112345

EXP DATE: 10/08

4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube

5- A/R 55-o-ring lube batch: 1101223

6-Coat all exposed fasteners with "LPS Procyon" batch: 110425

0.00

0.00

10/02/26

(X) 0

W/O:		WORK ORDER CHANGES					
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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

5/10/2/26

Memo

0.00

250



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

10-3-2

SP

260



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Sub/13

Memo

0.00

AL

*****ensure antiseize is on AN8C21A bolts*****

W/O:		WORK ORDER CHANGES					
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Work Order ID 55924

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

270



Packaging

Packaging

0.00

0.00

Rev H

10-3-4

sf

Memo

Package as per PPP D350-636-011

280



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

10/03/05

ME

10-3-4

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55924



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02.09.25 [Rearranged procedure steps] [KJ]
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D2594-3 Manufactured No 230 Each 700.0000 8.0000



O-Ring, 205 Skidtube

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 527

51613 27

55546 500

Main Warehouse

ST 173

52562 173

Y8 10/02/26

D2744 Manufactured No 110 Each 51.0000 1.0000



Cap

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 51

44892 1

47488 23

51922 27

1 10/2/3

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 55924



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev:J 02.09.25 Rearranged procedure steps (KJ)
 IPP Rev:J 06-03-23 As per Rev D JLM
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT

Manufactured No

110

Each

17.0000

1.0000



Extrusion Bent

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	12	
50675	2	
55462	10	
Main Warehouse		
ST	5	
43495	1	
47133	1	
52346	3	

D2743

Manufactured No

160

Each

227.0000

8.0000



Crossbolt Spacer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	52	
50281	50	
51913	2	
Main Warehouse		
ST	175	
44891	2	
45555	17	
48275	1	
52310	155	

1 11/10/2/10

8 10/22/10

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D2739 Manufactured No 160 Each 5.0000 1.0000



350 I Beam

Warehouse Loc Qty Loc Code

Location

Main Warehouse

B 55986

1 4 10/2/9

ST

5

47124

1

53900

2

55034

1

55569

1

D3490-3 Manufactured No 160 Each 69.0000 4.0000



Cross Bolt Spacer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG

60

55010

60

Main Warehouse

ST

9

45560

1

48276

4

51930

4

4 BE 10/02/10

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Shop Packet Print

Page 3

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Start Qty: 1.00

Required Qty: 1.00

D3490-1 Manufactured No 160 Each 52.0000 4.0000



Cross Bolt Spacer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	52
45338	2
47657	2
48277	9
51932	39

ALS4-1032-225 Purchased No 220 Each 6,420.000 38.0000



Insert

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	6420
107441	16
110768	6404

4 BE 10/02/10

X38 48 10/02/10

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Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 5

Work Order ID: 55924

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 102.09.25 Rearranged procedure steps JKL
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3492-041 Manufactured No 230 Each 121.0000 8.0000



Plug Assembly

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	121	
(51584)	44	
55446	77	

Y8 H 10/02/26

D3793-3 Manufactured No 230 Each 10.0000 1.0000



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	10	
(51592)	10	

X1 H 10/02/26

AN8C35A Purchased No 230 Each 131.0000 1.0000



BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	131	
102180	1	
106896	1	
110105	48	
(10847)	81	

X1 H 10/02/26

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 6

Work Order ID: 55924



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps I KJ I
IPP Rev: J 06-03-23 As per Rev D JLM
IPP Rev: K 06-07.13 As per dsi9343 EC
IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3793-1 Manufactured No 230 Each 15.0000 1.0000



Wearshoe

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 15

40551 1

51597 14

D3488-041 Manufactured No 230 Each 11.0000 1.0000



Blade Fitting Assembly, LH

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 11

47348 11

yl ul 10/02/26

yl ul 10/02/26

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 55924



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps: [KJ]
IPP Rev: J 06-03-23 As per Rev D JLM
IPP Rev: K 06-07.13 As per dsi9343 EC
IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230

Each

15.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

B56066

X1 9H 10/02/26

FP

12

51598

2

51907

10

Main Warehouse

ST

3

46531

2

47440

1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 8

Work Order ID: 55924



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps (KJ)
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

AN6C44A Purchased No 230 Each 116.0000 4.0000



BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	2	
103964	2	
Main Warehouse		
ST	114	
110105	4	
110155	14	
110665	1	
111605	42	
111649	50	
112720	1	
113121	2	

x4 47 10/02/26

MS21083C8 Purchased No 230 Each 78.0000 1.0000



NUT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	78	
110584	5	
111424	2	
113149	21	
113845	50	

x1 21 10/02/26

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 55924



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02.09.25 (Rearranged procedure steps KJ)
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3536-25 Manufactured No 230 Each 33.0000 1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP10

28

51607

2

54479

26

Main Warehouse

ST

5

45569

1

47011

2

47526

2

x1 10/02/26

D3631-1 Manufactured No 230 Each 394.0000 8.0000



Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

394

52693

94

54388

300

x8 10/02/26

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55924



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev:J 02.09.25 Rearranged procedure steps JKL
 IPP Rev:J 06-03-23 As per Rev D JLM
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Qty: 1.00

Required Qty: 1.00

D3791-1 Manufactured No 230 Each 5.0000 1.0000



Wearplate

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

2

51610

2

Main Warehouse

ST

3

51909

3

AN960C10L

Purchased No

230

Each

388.0000

38.0000



washer

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG

100

103585

100

Main Warehouse

ST

288

112116

128

112612

160

X NAS 1149C0332R

M113737

x3B 2/10/02/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 55924



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02.09.25 [] Rearranged procedure steps [] KJ []
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D2745 Manufactured No 230 Each 298.0000 8.0000



Bushing

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	36	
43754	2	
44893	33	
45556	1	
Main Warehouse		
ST023	23	
34817	2	
36230	8	
37303	1	
39587	2	
40726	2	
41114	2	
42778	6	
Main Warehouse		
ST46	239	
51537	54	
51910	4	
52311	181	

x8 Jd 10/02/20

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55924



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev:J 02.09.25 Rearranged procedure steps [KJ]
 IPP Rev:J 06-03-23 As per Rev D JLM
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Qty: 1.00

Required Qty: 1.00

AN3C5A Purchased No 230 Each 706.0000 34.0000



Bolt

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	706	
111424	8	
111707	69	
112314	1	
113121	214	
113149	300	
113644	114	

x34 Jul 10/02/26

D3537-1 Manufactured No 230 Each 90.0000 3.0000



Wearpad

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP	2	
48288	2	
Main Warehouse		
FP17	88	
51678	1	
51679	87	

x3 Jul 10/02/26

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 13

Work Order ID: 55924



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps JLM
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

AN960C816L

Purchased No

230

Each

216.0000

1.0000



WASHER

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

216

104093

2

107520

4

110139

29

110584

100

111424

81

xi 24 10/02/26

D3492-043

Manufactured No

230

Each

95.0000

8.0000



Plug Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

91

54682

91

Main Warehouse

ST

4

52309

4

x8 24 10/02/26

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 55924



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 102.09.25 Rearranged procedure steps: J K J
IPP Rev: J 06-03-23 As per Rev D JLM
IPP Rev: K 06-07.13 As per dsi9343 EC
IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

AN3C6A Purchased No 230 Each 778.0000 4.0000



BOLT

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

778

111982

778

y4 JU 10/02/26

NAS1611-013 Purchased No 230 Each 142.0000 8.0000



O-RING



Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP

100

113743

100

Main Warehouse

ST

42

106513

11

111424

20

111758

11

y8 JU 10/02/26

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 55924



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: H 02.09.25 (Rearranged procedure steps) KJ
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3535-25 Manufactured No 230 Each 8.0000 1.0000



Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

2

51927

2

Main Warehouse

ST

6

52589

6

ST 10/02/26

D3794-1 Manufactured No 230 Each 21.0000 1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

18

51928

6

5459

12

Main Warehouse

ST

3

46530

1

47212

2

ST 10/02/28

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 55924

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev:J 02.09.25 Rearranged procedure steps [KJ]
 IPP Rev:J 06-03-23 As per Rev D JLM
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Qty: 1.00

Required Qty: 1.00

MS21043-6 Purchased No 230 Each 976.0000 4.0000



NUT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

976

112314

976

D3493-1

Manufactured No

260

Each

41.0000

2.0000



Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

41

44902

2

47710

39

MS21083C8

Purchased No

260

Each

78.0000

2.0000



NUT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

78

110584

5

111424

2

113149

21

113845

50

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 55924



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev:J 02.09.25 Rearranged procedure steps KJ
 IPP Rev:J 06-03-23 As per Rev D JLM
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

260

Each

130.0000

2.0000



BOLT



10-3-2 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

130

105160

1

107596

1

107924

2

109092

2

110341

2

110342

2

111605

50

112720

20

113558

50

XZ

AN960C816L

Purchased

No

260

Each

216.0000

2.0000



WASHER



10-3-2 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

216

104093

2

107520

4

110139

29

110584

100

111424

81

2

February 4, 2010 2:34:49 PM

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 55924



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps [KJ]
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3672-1 Manufactured No 230 Each 1,720.000 4.0000



Phenolic Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

B 47628

x4 26 10/02/26

ST

1220

39275

19

42329

5

47628

196

52505

1000

Main Warehouse

ST117

500

51674

500

D2741 Manufactured No 260 Each 24.0000 1.0000



Blade, 350 Skidtube

14-3-2 sf

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

24

51931

24

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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February 4, 2010 2:34:54 PM

Page 19

Work Order ID: 55924



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 2/04/10

Required Date: 2/12/10

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps [KJ]
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC

Start Qty: 1.00

Required Qty: 1.00

D3532-1 Manufactured No 260 Each 68.0000 2.0000



Spacer

10-3-2 SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 68

44904 2

52321 66

D3672-13 Purchased No 260 Each 934.0000 2.0000



Phenolic Washer

10-3-2 SP (10)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 934

54363 934

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 55924
BJ 10-2-04

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GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB. POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3. BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.16		
DART AEROSPACE USA, INC. PORT HADLOCK, WA			
DRAWING NO. D2750		REV. F	
TITLE		SHEET 1 OF 11	
350 SKIDTUBE ASSEMBLY		SCALE	
		NTS	
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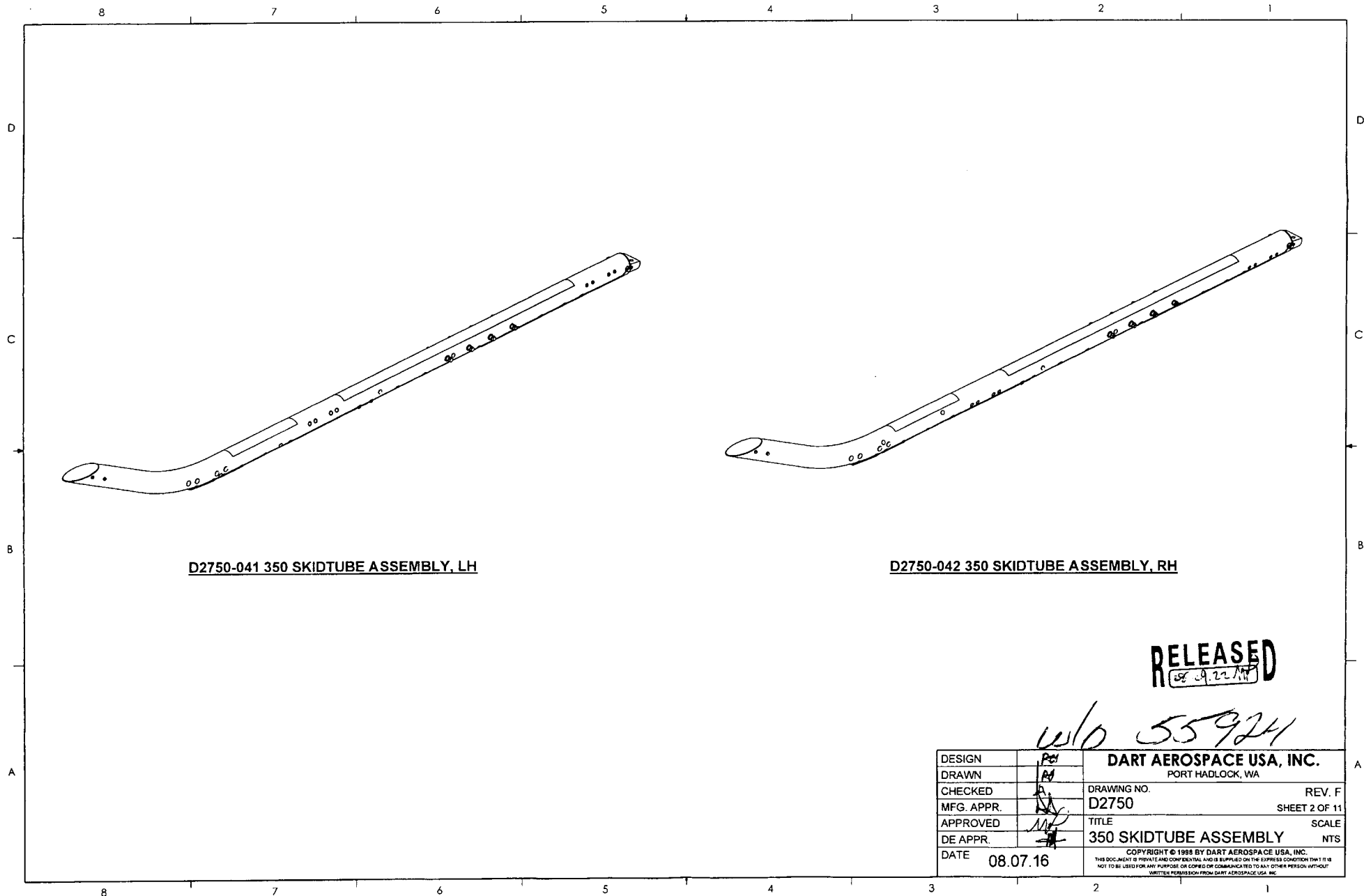
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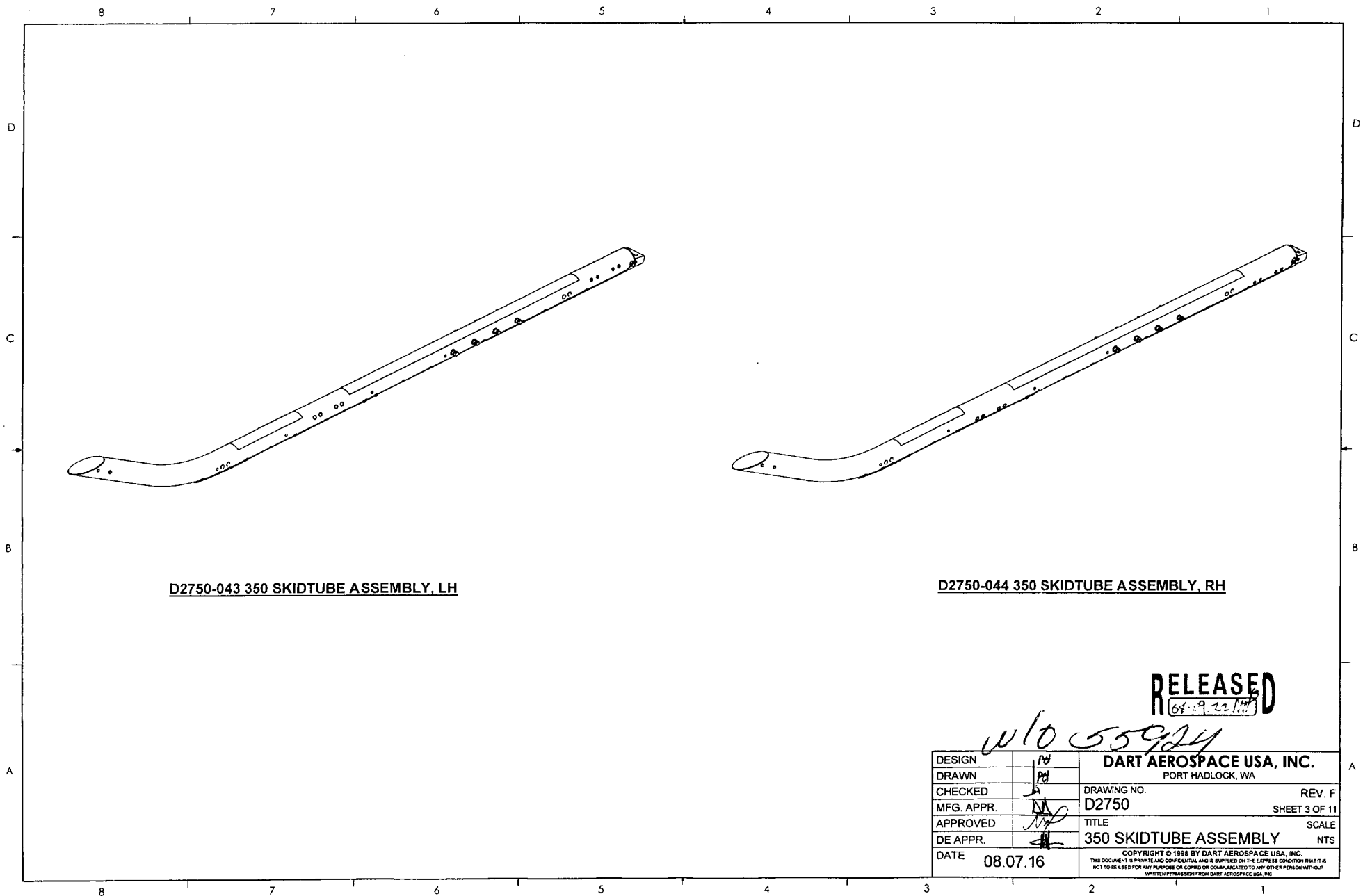
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D2750-043 350 SKIDTUBE ASSEMBLY, LH

D2750-044 350 SKIDTUBE ASSEMBLY, RH

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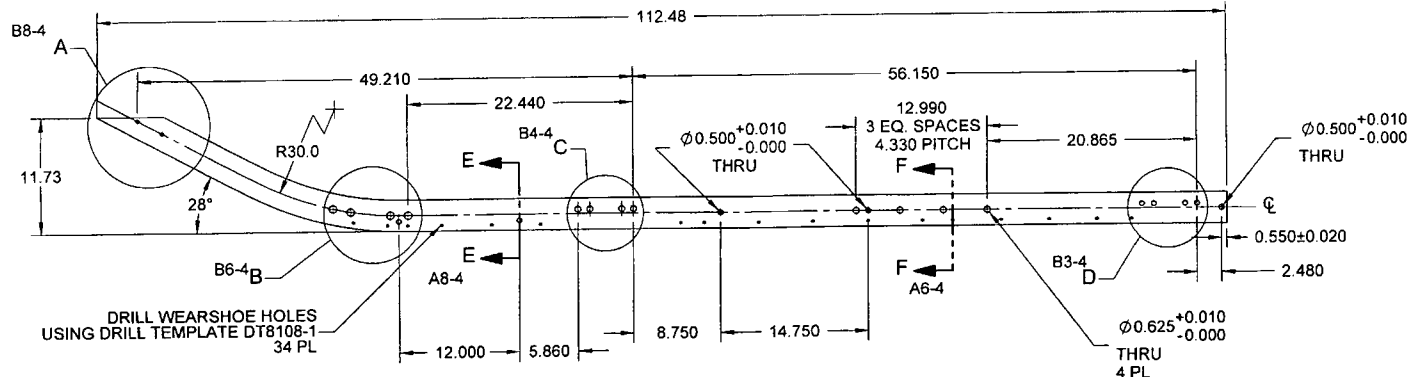
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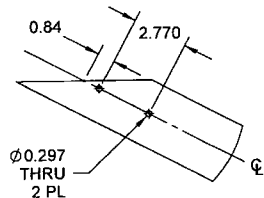
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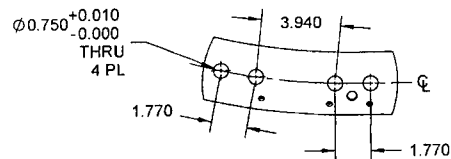
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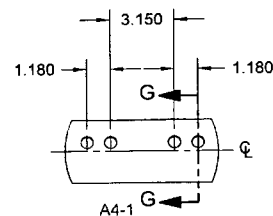
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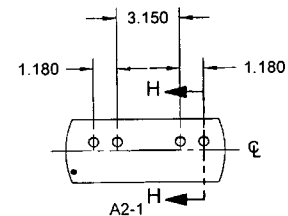
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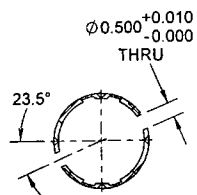
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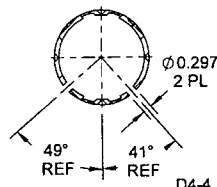
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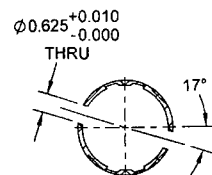
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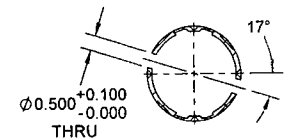
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SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

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TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
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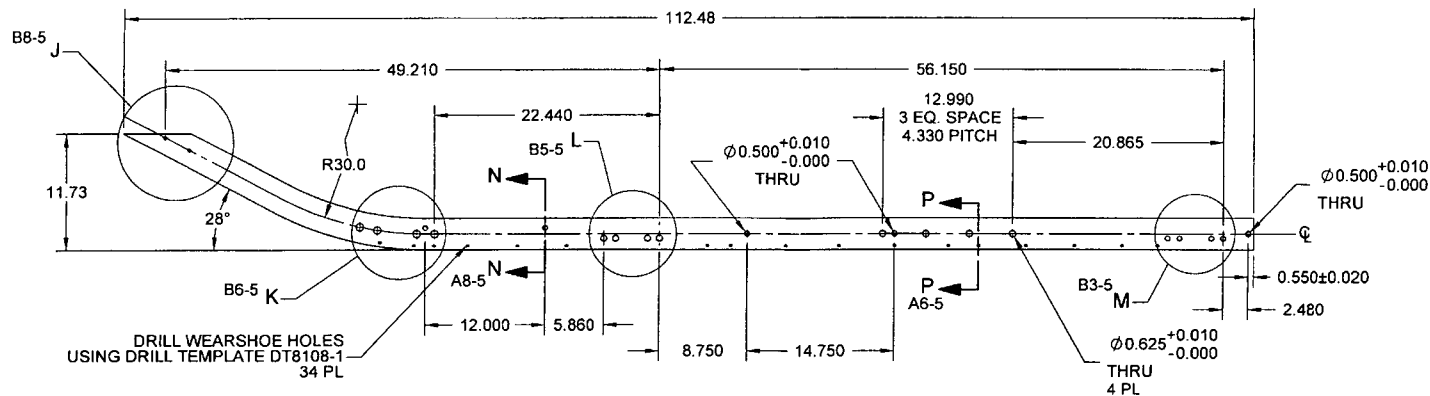
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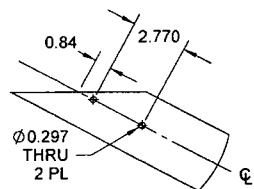
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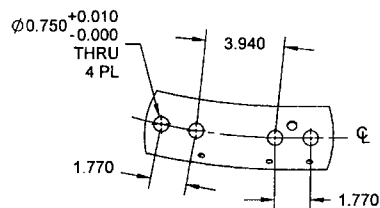
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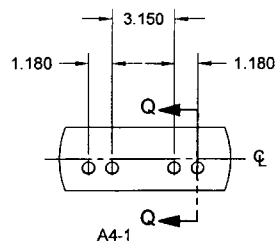
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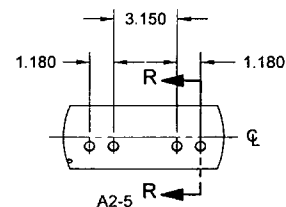
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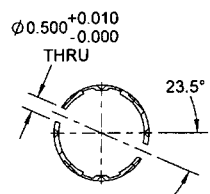
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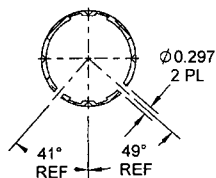
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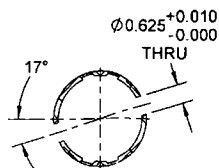
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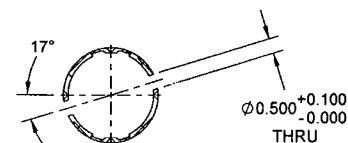
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SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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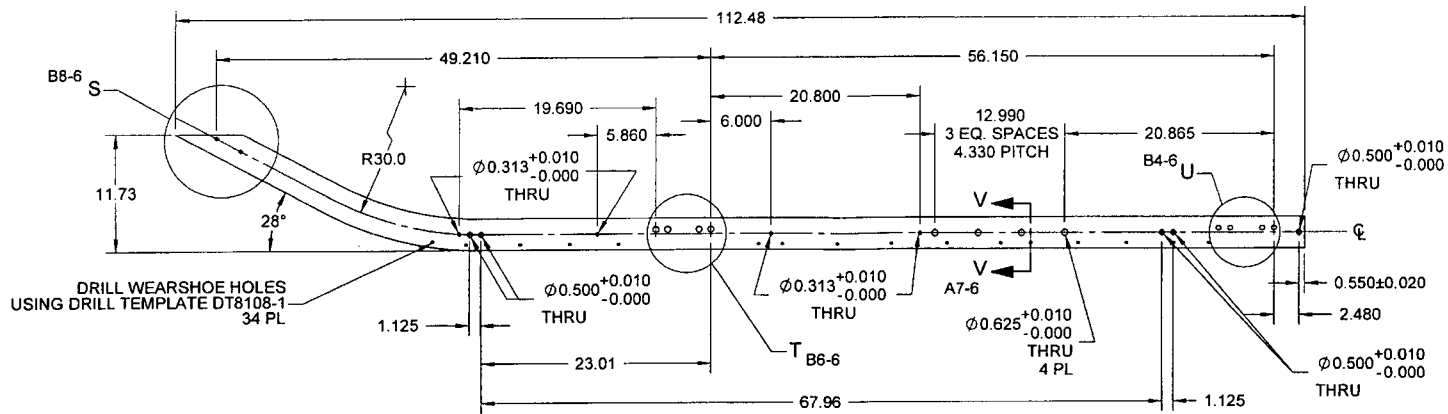
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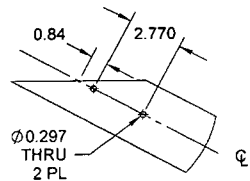
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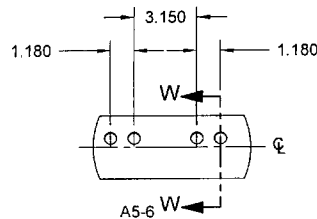
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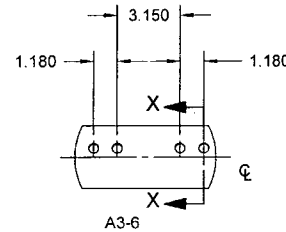
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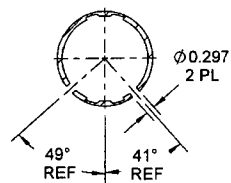
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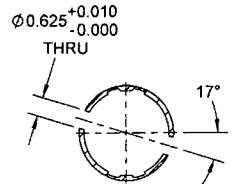
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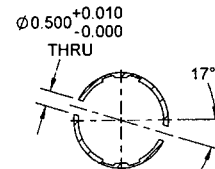
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SECTION V-V
SCALE 3X, 17 PL




SECTION W-W
SCALE 3X, 4 PL



SECTION X-X
SCALE 3X, 4 PL

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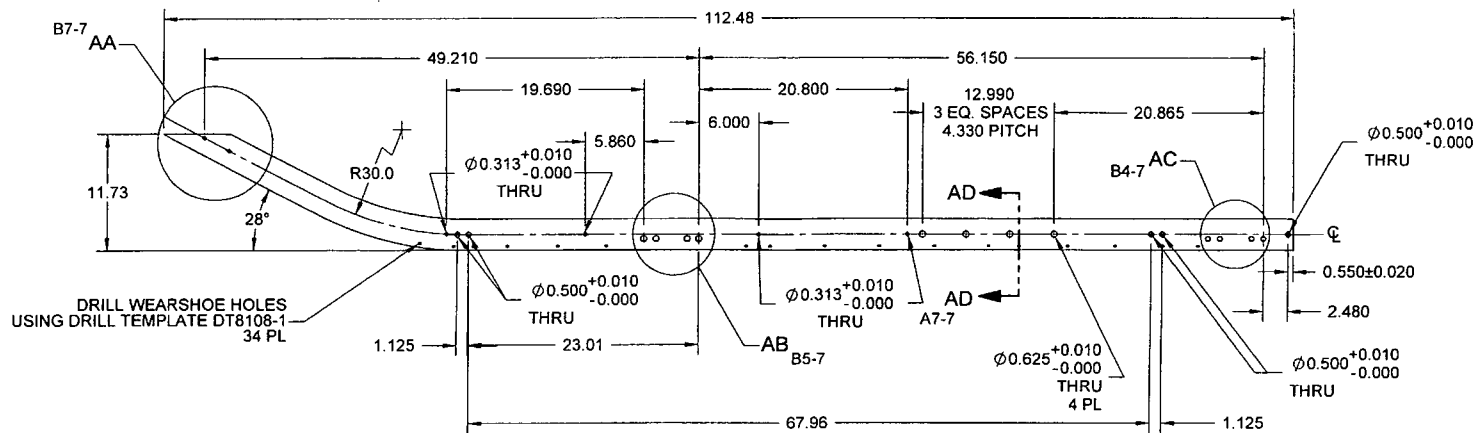
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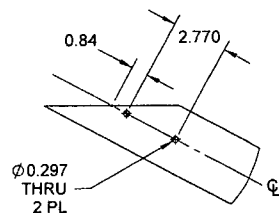
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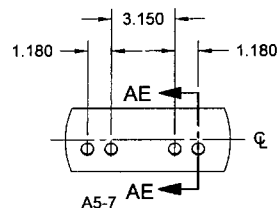
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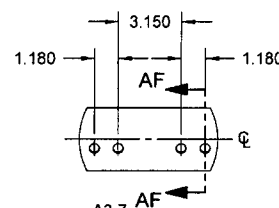
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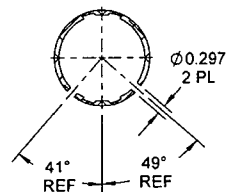
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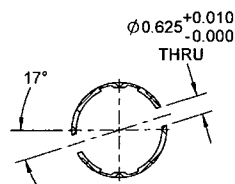
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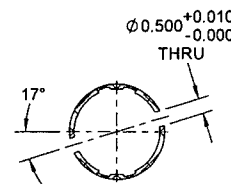
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SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL



SECTION AF-AF
SCALE 3X, 4 PL

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APPROVED	PA	TITLE	SCALE
DE APPR.	PA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

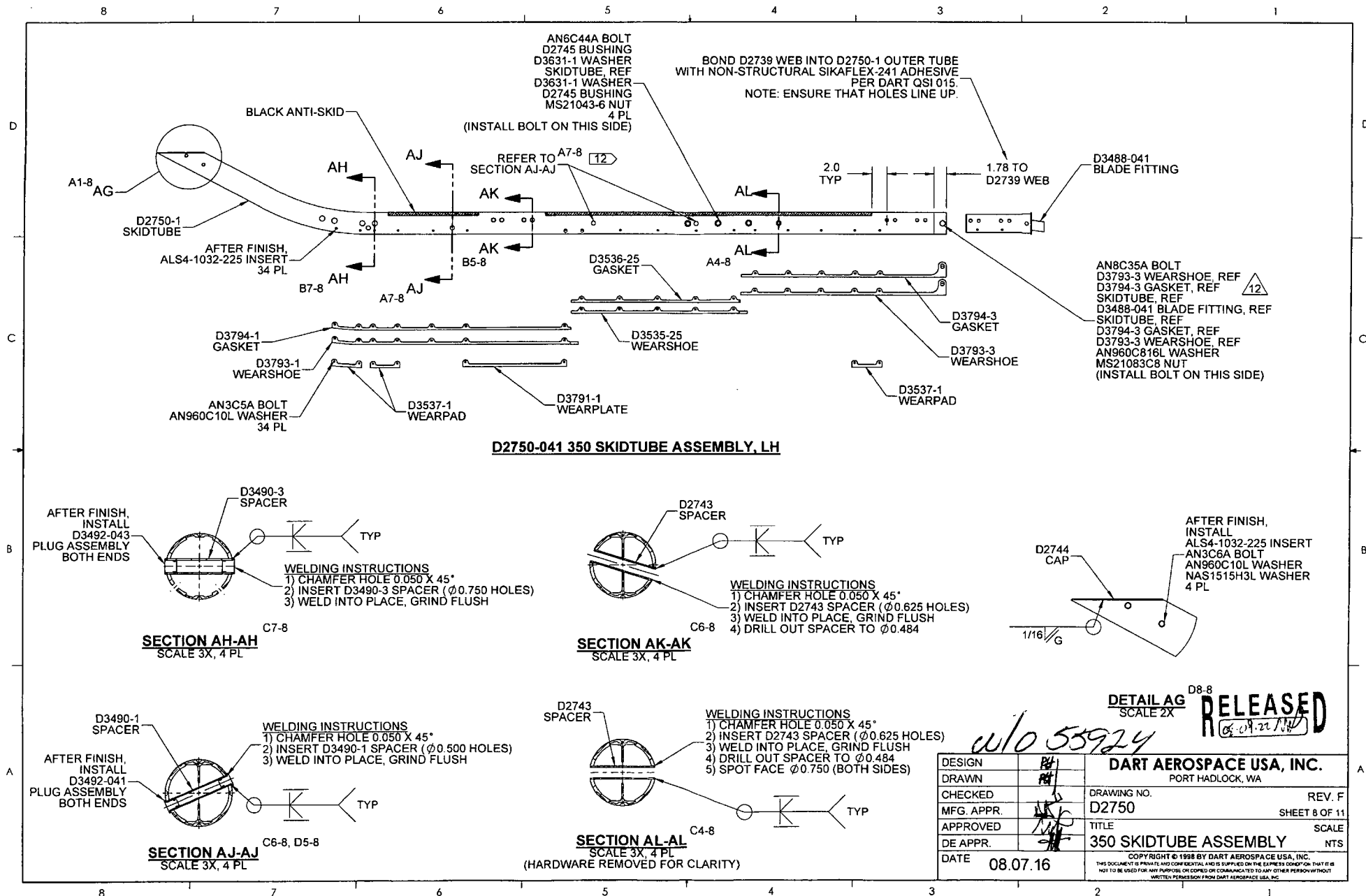
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
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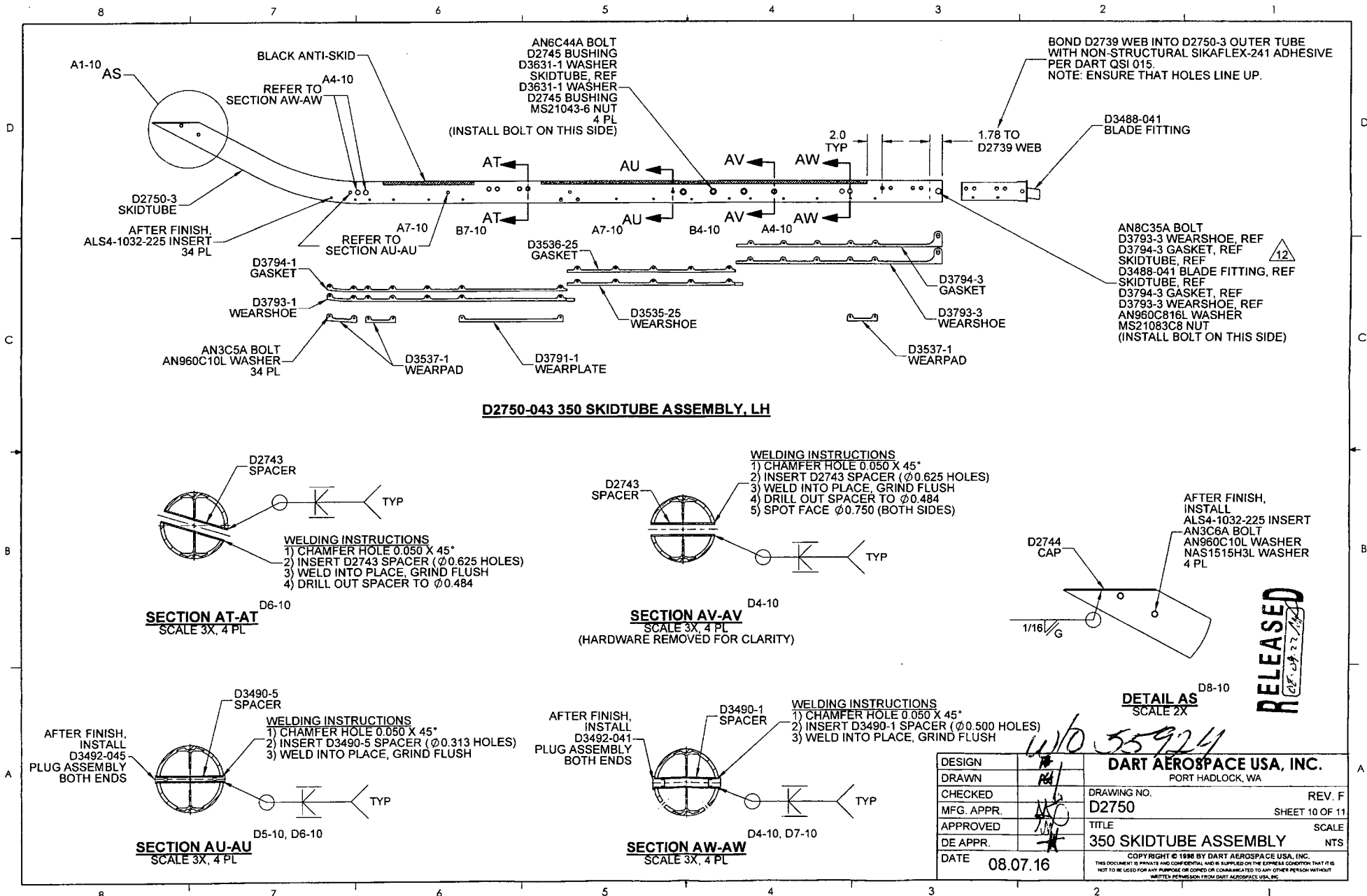
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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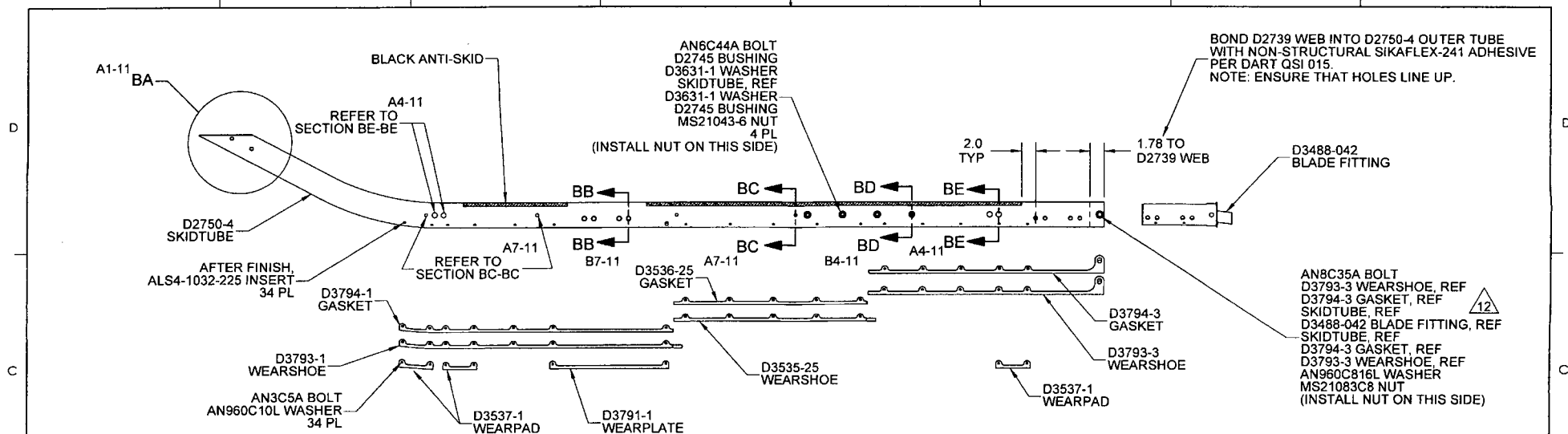
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

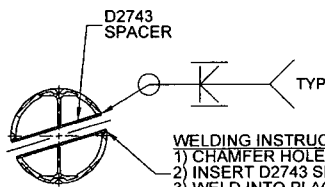
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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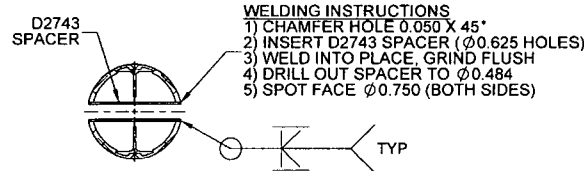
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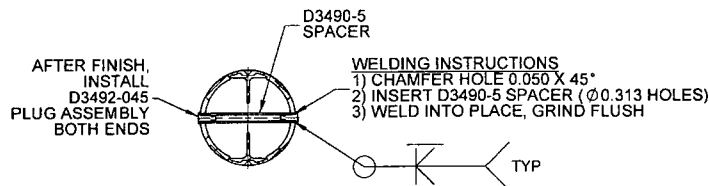
D2750-044 350 SKIDTUBE ASSEMBLY, RH



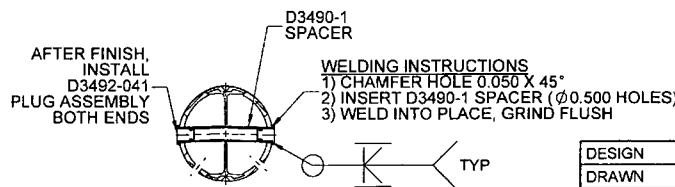
SECTION BB-BB
SCALE 3X, 4 PL



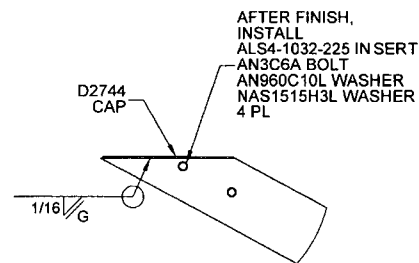
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

DESIGN	W/P 5592	DART AEROSPACE USA, INC.	
DRAWN	W/P 5592	PORT HADLOCK, WA	
CHECKED	W/P 5592	DRAWING NO.	REV. F
MFG. APPR.	W/P 5592	D2750	SHEET 11 OF 11
APPROVED	W/P 5592	TITLE	SCALE
DE APPR.	W/P 5592	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.	
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RELEASED

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

NO. 222

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 54956
Part number: D350-636-012
Description: 350 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat. Don. Date of Test Coupon 10-01-11

Welder Barclay Elliott Date of Test Coupon 10-01-11

The above named individual is qualified in accordance with AWS D17.1.2001 to weld